

Work Order ID 64822

Friday, December 17, 2010 8:03:39 AM



Page 1

Item ID:	D3213-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Door Assembly					
Start Date:	12/16/2010	Start Qty:	4.00 ¹⁰	Cust Item ID:		
Required Date:	1/19/2011	Req'd Qty:	4.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	10/27	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3213	Rev A

100		0.00	
	Small Fab		
Small Fab	Memo	0.00	
Small Fab	I-Assemble as per Dwg D3213 Transfer drill hinge using DT8470 & DT9520		

Identify as D3213-041

110		0.00	
	QC5- Inspect part completeness to step on W/O		
QC	Memo	0.00	
Quality Control			

120		0.00	
	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3		
Powdercoat	Memo	0.00	
Powder Coating	START TIME: 8:55	OVEN TEMPERATURE:	
	FINISH TIME: 9:05		

10 BR 11-02-10.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64822

Friday, December 17, 2010 8:03:39 AM

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Item ID: D3213-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Door Assembly

Start Date: 12/16/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

⇒



QC

Memo

0.00

Quality Control

10 0 11/02/10

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3213

ES 11/02/14 (10)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sul 02/14

(40)

W/O:		WORK ORDER CHANGES					
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Work Order ID 64822

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Item ID: D3213-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Assembly

Start Date: 12/16/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Packaging Packaging	Identify as per dwg & Stock Location: <u>211</u> Memo	0.00 0.00							<u>1/11/14</u> (10)
170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>1/10/14</u> <u>mr</u> <u>11-02-14</u>

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NOTE: Date & initial all entries

Picklist Print

Friday, December 17, 2010 8:03:44 AM

Page 1

Work Order ID: 64822

Parent Item: D3213-041

Parent Item Name: Door Assembly



Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-11-17 17:27

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
* D3161-3 Hinge 15.0"		Manufactured	No			100	Each	3.0000	2	8			
D3213-1 Door Panel		Manufactured	No			100	Each	4.0000	1	4			
* D3213-3 Door Panel		Manufactured	No			100	Each	7.0000	1	4			

Location

ST040

48537

Loc Qty

3

3

Loc Code



EP 11/02/08

B65023 (12x)

Location

ST232B

48497-1

Loc Qty

4

4

Loc Code



EP 11/02/08

B65142 (6x)

Location

ST211

44233

ST232B

48498

Loc Qty

1

1

6

18

Loc Code



EP 11/02/08

B65143 (2x)

8

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 64822

Parent Item: D3213-041

Parent Item Name: Door Assembly

Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 4.00

Required Qty: 4.00

MS20470AD4-6

Purchased

No

100

Each

3,641.000

1

4



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

3030

116391

3030

ST320

611

114988

611

ES 4/02/10

AN960JD6

NAS1149DN632

Purchased

No

140

Each

436.0000

1

4



Washer

Location

Loc Qty

Loc Code

ST347

436

104537

436

ES 4/02/10

D2137

Manufactured

No

140

Each

12.0000

1

4



Decal - No Step

Location

Loc Qty

Loc Code

ST006

12

59395

2

62071

10

ES 4/02/10

B65.121 (100)

D2419

Manufactured

No

140

Each

21.0000

1

4



Handle

Location

Loc Qty

Loc Code

ST014

21

63423

21

ES 4/02/10

10

Friday, December 17, 2010 8:03:44 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Parent Item: D3213-041

Parent Item Name: Door Assembly

Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 4.00

Required Qty: 4.00

D2462
Seal

Manufactured No

140

f

603.6009

2.4

9.6



ES 11/02/10

Location

Loc Qty

Loc Code

ST404

603.6009

48530

603.6009

24

D2728-1
Dart Logo label

Manufactured No

140

Each

0.0000

0

0

MS20470AD4-4

Purchased No

140

Each

6,314.000

24

96



ES 11/02/08

Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

6314

112314

30

113368

92

116188

2556

116391

3636

240

W/O:		WORK ORDER CHANGES					
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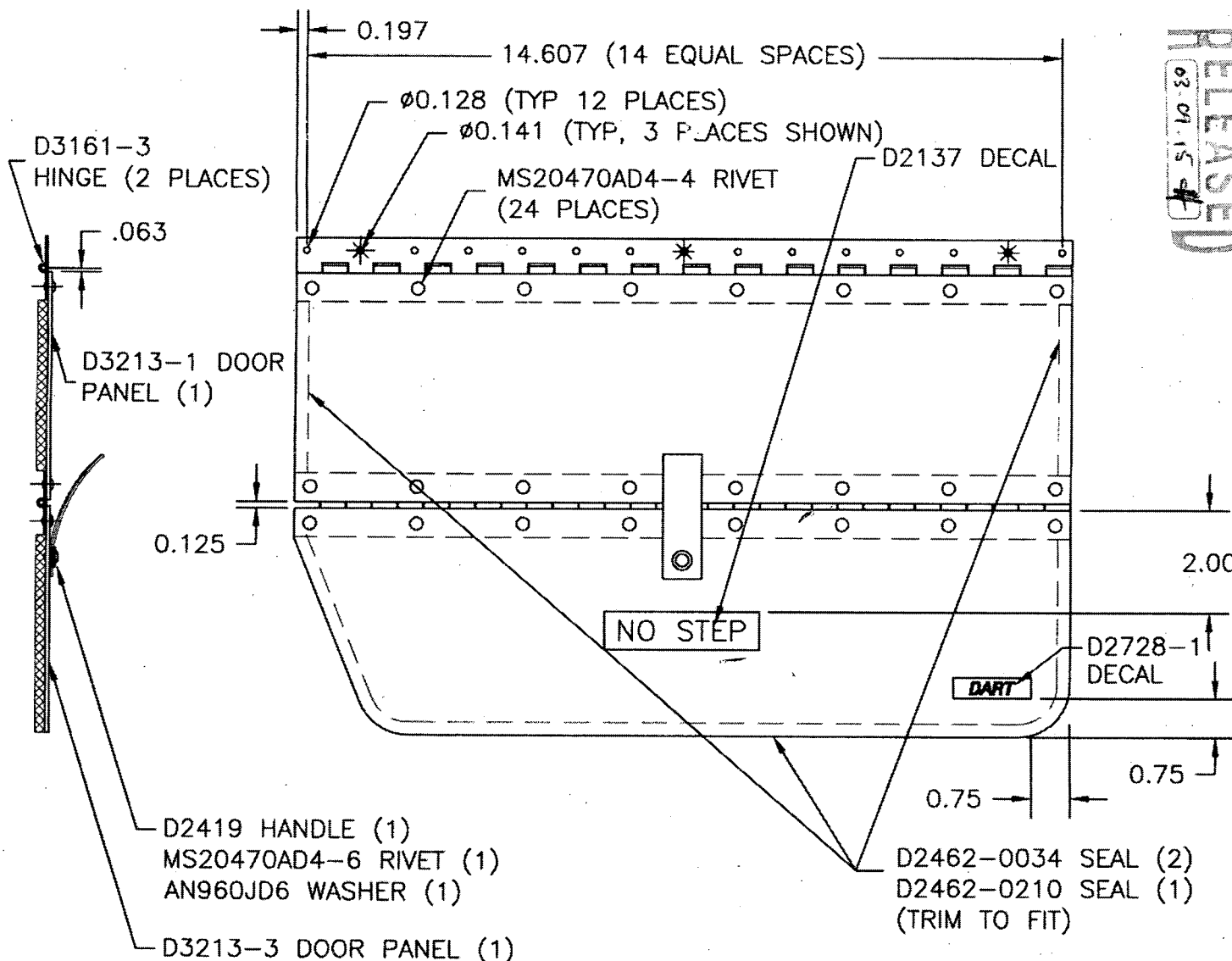
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE

ORDER NO. *141822*
2802-07



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3213
DATE 03.09.03	TITLE DOOR ASSEMBLY	REV. A 1 OF 2
A	03.09.03	SCALE 1:3
	NEW ISSUE	

RELEASED
03-01-15-4



D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

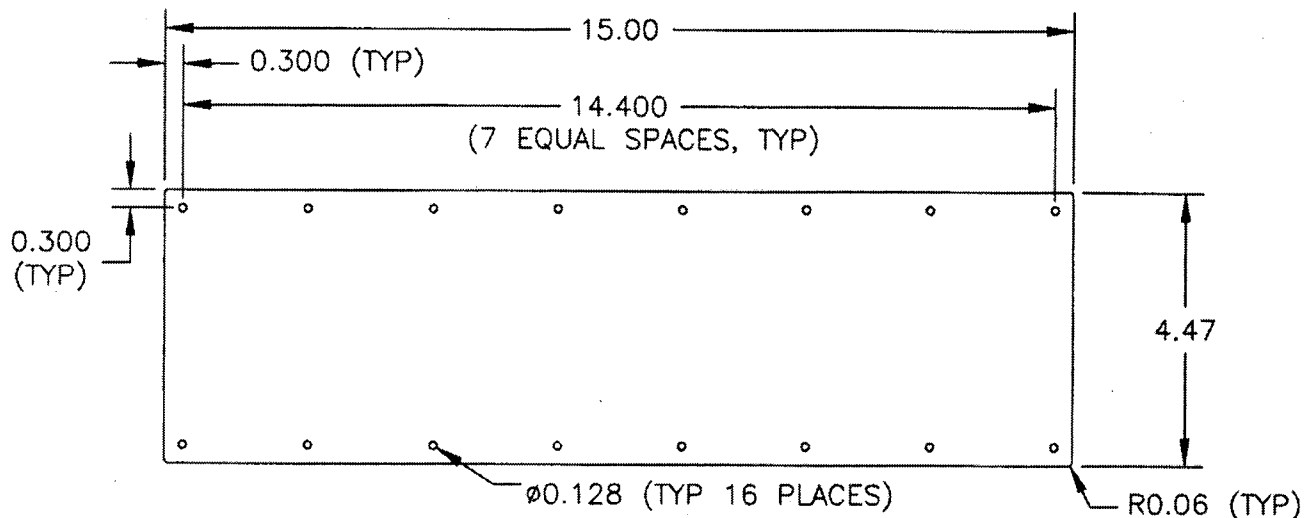
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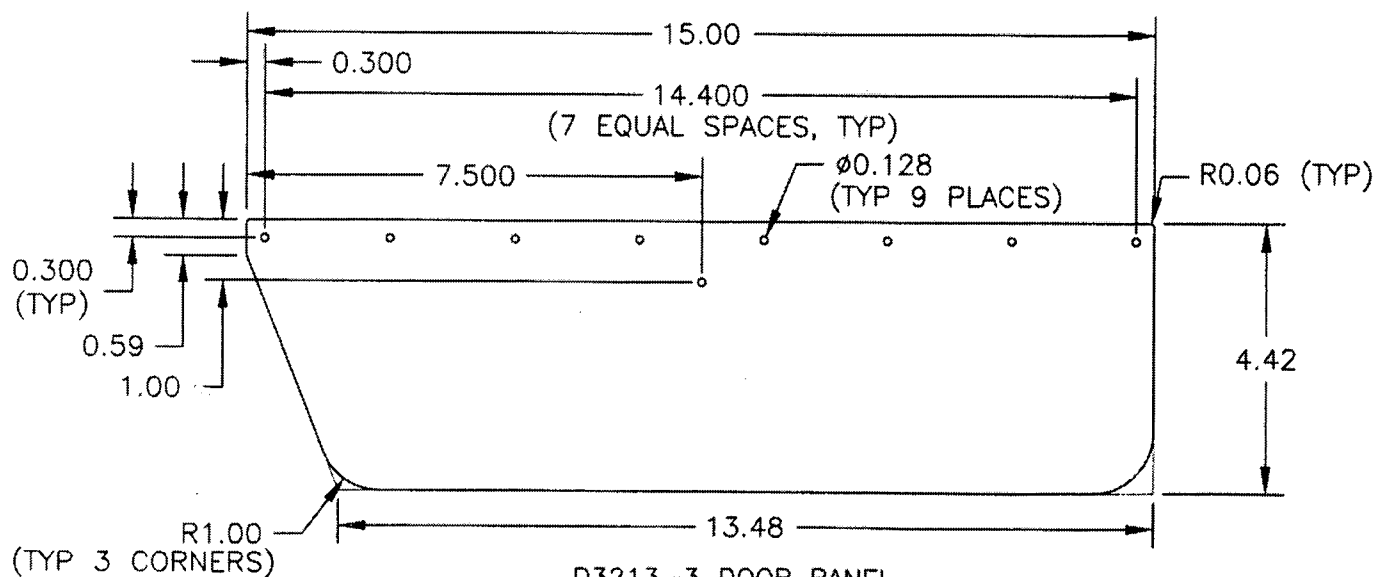


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3213	REV. A 2 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3



D3213-1 DOOR PANEL

w/064822



D3213-3 DOOR PANEL

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03.09.15 *[Signature]*

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